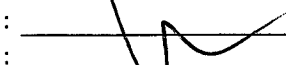


Date: Friday, 15/02/2008 9:21:10 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARING ASSEMBLY
Job Number :	37470		
Estimate Number :	10716		
P.O. Number :		Part Number :	D3121241
This Issue :	15/02/2008	Drawing Number :	D3121 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	E
Previous Run :	36669	Material :	
Written By :		Due Date :	22/02/2008
Checked & Approved By :		Qty:	13
Comment :	Um: Each		
	Est Rev:A 04/02/18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MDELNR12500	DELIN ROUND BAR 1.25"
-----	-------------	-----------------------



Comment: Qty.: 0.0546 f(s)/Unit Total : 0.7098 f(s)
 Material: Ø1.25 Delrin Rod
 (M-DELIN-R1.2500)Identify as D3121-25
 Batch: _____

D3121-25

B 36 151

JF 08/02/15

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

JL/A

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	D312123	Bearing
-----	---------	---------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3121-23	Bearing	36670

JF 08/02/15

Date: Friday, 15/02/2008 9:21:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 37470

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

S.F 05/02/15 (13)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/15 (13)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 36663

S.F 08/02/15

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(13)

2008/03/04

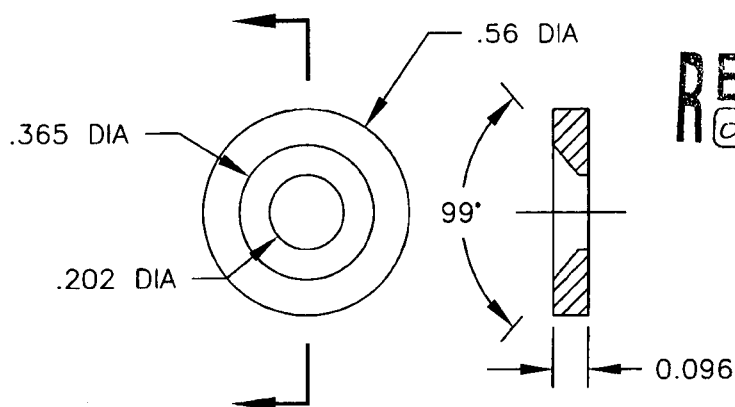
Job Completion



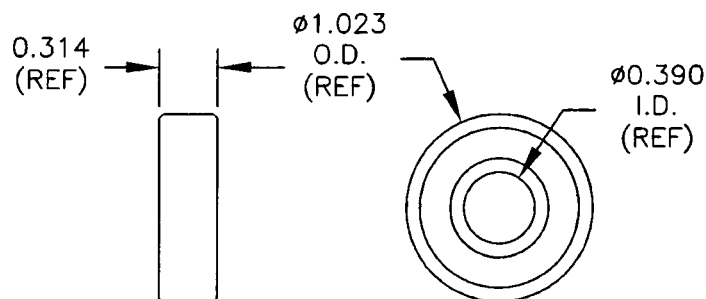
mi 2008/3/04 (13)

DART

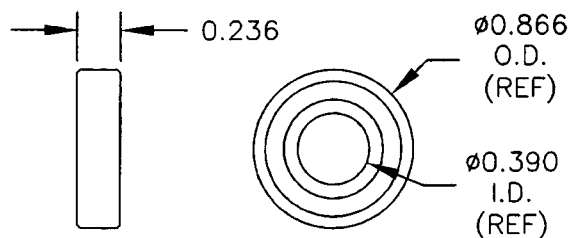
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

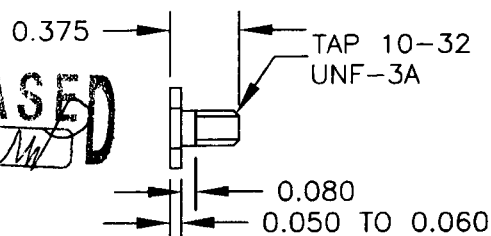
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

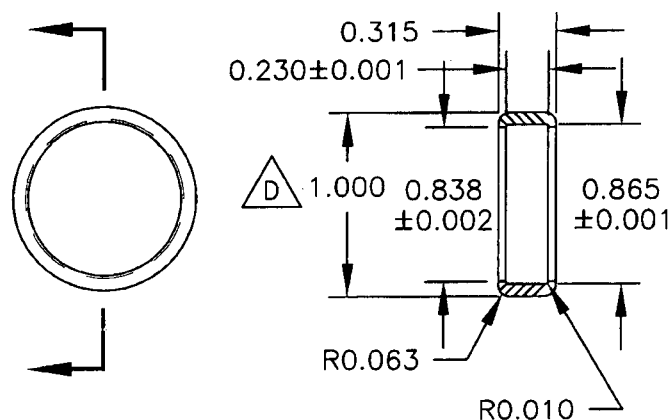
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

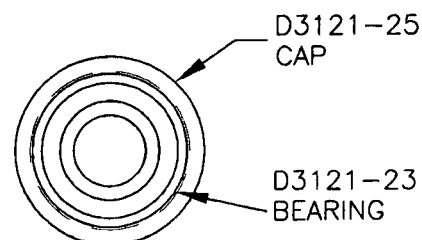
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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